

Work Order ID 72068

Friday, July 22, 2011 9:55:56 AM



MAT BLACKS

Ship Aug 10th

Page 1

Item ID: D2572

Accept



Setup Start



Revision ID:

Item Name: Saddle, Fwd In 205

Stop



Start Date: 7/19/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

MF

Date:

11-07-12

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2572

Rev E

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. *72068 F.K.*

Double check by: *SK*

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and insp

ent 11/08/05

2 0

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2571 & D2572

ent 11/08/05

2 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72068

Friday, July 22, 2011 9:55:56 AM



Page 2

Item ID: D2572

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd In 205

Start Date: 7/19/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

enl 11/08/08

QC

Memo

0.00

Quality Control

2 *0*

130

QC8- Inspect parts - second check

0.00

B.A 11/08/08

QC

Memo

0.00

Quality Control

2 *0*

140

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

2x0 M.K 11/08/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72068

Friday, July 22, 2011 9:55:56 AM



Page 3

Item ID: D2572

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd In 205

Start Date: 7/19/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

111512F

Memo

0.00

START TIME: 2:30pm OVEN TEMPERATURE:
3:00pm FINISH TIME: 3:20pm

12 d 11/08/08

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

2x 0 m-h 11/08/08

170



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

0.00

Pup/s (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72068

Friday, July 22, 2011 9:55:56 AM



Page 4

Item ID: D2572

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd In 205

Start Date: 7/19/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/08/10

11-08-9
(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Tuesday, July 19, 2011 9:03:39 AM

Work Order ID: 72068



Parent Item: D2572



Parent Item Name: Saddle, Fwd In 205

Start Date: 7/19/2011

Required Date: 7/29/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: I 02.10.02 Re-format; Change to Dwg Rev. D & incorporated
D2572 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-005		Manufactured	No			100	Each	3.0000	1	2			
Saddle Billet													

15.K. 11/08/04

Location

Loc Qty

Loc Code

MAT046

3

66966

3

D71721

2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	72068
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.440	.440				
B	1.745	1.755		1.749	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.749	1.750				
E	7.990	8.010		8.003	8.000				
F	0.490	0.510		.500	.500				
G	0.257	0.262		.257	.258				
H	0.375	0.380		.375	.377				
I	0.490	0.510		.502	.498				
J	1.174	1.184		1.178	1.177				
K	0.558	0.578		.569	.566				
L	1.174	1.184		1.177	1.177				
M	1.490	1.500		1.493	1.493				
N	2.495	2.505		2.498	2.498				
O	3.869	3.879		3.871	3.872				
P	0.115	0.135		.125	.125				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.251	.257				
S	0.115	0.135		.130	.130				
T	0.178	0.198		.188	.188				
U	2.940	2.980		2.964	2.960				
V	0.230	0.250		.244	.240				
W	0.115	0.135		.121	.123				
X	0.307	0.312		.312	.312				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.366	.365				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.623	.624				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.253	.247				
AE	1.375	1.395		1.383	1.385				
AF	0.115	0.135		.135	.135				
AG	0.240	0.280		.250	.250				
AH	0.240	0.260		.254	.250				
AI	2.000	2.020		2.000	2.001				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

Measured by:	SM
Date:	11/08/05

Audited by:	H.A
Date:	11/08/08

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 7206

RELEASED

05.12.06

NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3

BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

1 ENGRAVE PART AND BATCH NUMBER IN THIS
AREA TO MAX DEPTH OF 0.010

CHAMFER 0.063" x 45° AROUND THIS SURFACE
(TYPICAL 2 PLACES)

3 CHAMFER 0.063 x 45° ALL AROUND

CHAMFER 0.033 x 45° (SEE DETAIL C)

$$\triangle E$$

VIEW B-B

SECTION A-A

DETAIL C
SCALE 2:1

COPYRIGHT © 2008 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

DESIGN	DS
--------	----

DRAWN BY PH

DART

DART AEROSPACE LTD.
HAMPSHIRE, ONTARIO, CANADA

CHECKED	
---------	--

APPROVED

	DRAWING NO.
	D2572

REV. E

SHEET 1 OF

DATE

02072	
TITLE	
NAME	

SCALE

05.07.13

INNER FWD SADDLE	
------------------	--

2:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries